

JAN 2015

Work Order ID 126966

126966

Page 1

Wednesday, December 03, 2014 9:54:41 AM

Item ID: D350-567-141

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Floor Window Close Out

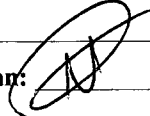
Start Date: 12/15/14 Start Qty: 2.00 *2*

Cust Item ID:

Required Date: 12/19/14 Req'd Qty: 2.00 *2*

Customer:

Reference:

Approvals: Process Plan: 

Date: 14-12-03

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9590	E								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D350-567-141 CHG003								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

EAS

45

JAN 19 2015

2x

EAS

45

JAN 19 2015

EAS

45

2x

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 126966

Wednesday, December 03, 2014 9:54:41 AM

126966

Page 2

Item ID: D350-567-141

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Floor Window Close Out

Start Date: 12/15/14 Start Qty: 2.00

2

Cust Item ID:

Required Date: 12/19/14 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00					LAS		
130						(2x)			
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-567-141 Location: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

JAN 19 2015

15/1/19

(15-1-19)

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
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Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Wednesday, December 03, 2014 9:56:06 AM

Page 1

Work Order ID: 126966

126966

Parent Item: D350-567-141

D350-567-141

Parent Item Name: Floor Window Close Out

Start Date: 12/15/14

Required Date: 12/19/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 11.11.09 new issue DD verf:JLM IPP REV:B
12.01.23 AS PER ECN12-511 DD VERF:EC IPP REV:C 12.03.05
AS PER ECN12-537 DD VERF:EC IPP REV:C 13.04.01 AS PER
DSI9590 REV.E DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3802-1		Manufactured	No			110	f	220.0100	2	4			
D3802-1 Windows Seal (\$ Per Foot) DAS 38 9-89													
Location Loc Qty Loc Code													
ST421 220.01													
112283 48													
114190 9													
116673 10													
117766 0.01													
122222 153													

(D3802-1-024) CUT (1) AT 24" AS PER DWG, PER KIT.

D4434-041		Manufactured	No			110	Each	0.0000	2				
D4434-041 Fwd Bracket Assembly DAS 06 9-89													

D4435-045		Manufactured	No			110	Each	5.0000	2				
-----------	--	--------------	----	--	--	-----	------	--------	---	--	--	--	--

D4435-045 T/R Bellcrank Cover Assembly DAS 06 9-89												
Location Loc Qty Loc Code												
ST620 5												
124198 5												

JAN 12 2015

68-6
99
SVC

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐									
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Picklist Print

Wednesday, December 03, 2014 9:56:06 AM

Page 2

Work Order ID: 126966

126966

Parent Item: D350-567-141

D350-567-141

Parent Item Name: Floor Window Close Out

Start Date: 12/15/14

Required Date: 12/19/14

Start Qty: 2.00

Required Qty: 2.00

D4435-9 Manufactured No 110 Each 4.0000

D4435-9

Bracket

2 4
** (126472)

DAS
06
9-89

Location Loc Qty Loc Code

ST107 4

125330 4

D4436-041 Manufactured No 110 Each 0.0000

D4436-041

Aft Bracket Assembly

1 2
** (123468)

DAS
06
9-89

D4441-1 Manufactured No 110 f 431.7478

D4441-1

Rubber Seal

2 4
**

DAS
06
9-89

Location Loc Qty Loc Code

ST407 430.7478

120932 430.7478

ST422 1

86185 1

DAS
38
9-89

DAS
06
9-89

(D4441-1-240) CUT (1) AT 24.00" PER KIT

AN3-3A Purchased No 110 Each 380.0000

AN3-3A

Bolt

7 14
**

JAN 12 2015

DAS
06
9-89

Location Loc Qty Loc Code

ST338a 360

m129591 360

ST350 20

m127815 3

m129706 1

m130466 16

Wednesday, December 03, 2014 9:56:06 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
☐ Bending	☐ Bend	☐ Folio/Program
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain
☐ Cracks	☐ Broken/Damage/Defect	☐ Hardware
☐ Crimp/Kink/Ripple/Wave	☐ Burrs	☐ Inspection Incomplete/Unqualified
☐ Cuffs	☐ Contamination	☐ Instructions Incomplete/Unclear
☐ Crushing	☐ Countersink	☐ Misaligned/off center
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled
☐ Inspection Strip in Tube	☐ Drawing	☐ Misread
☐ Marks/Chatter	☐ Drill Holes	☐ Off-set
☐ Turning Sequence	☐ Finish	☐ Out of Calibration
☐ Wave/Twist in Tube	☐ Fit/Function	☐ Out of Sequence
		☐ Outside Dimensions
		☐ Over/Under tolerance
		☐ Part Incorrect
		☐ Part Lost/Missing
		☐ Part Moved
		☐ Positioned Wrong
		☐ Power Loss/Surge
		☐ Pressure/Forced
		☐ Set-up
		☐ Temperature/Cure
		☐ Weld
		☐ Wrong Stock Pulled
		☐ Other

Picklist Print

Wednesday, December 03, 2014 9:56:06 AM

Work Order ID: 126966

126966

Parent Item: D350-567-141

D350-567-141

Parent Item Name: Floor Window Close Out

Start Date: 12/15/14

Required Date: 12/19/14

Start Qty: 2.00

Required Qty: 2.00

AN525-10R6

Purchased

No

110

Each

210.0000

2 4

DAS
06
3-89

AN525-10R6

Screw

**

LAS

Location

Loc Qty

Loc Code

ST273A

100

M129390

100

ST329

110

M127743

18

M130005

7

M130325

85

AN525-832R7

Purchased

No

110

Each

106.0000

2 4

DAS
06
3-89

AN525-832R7

Screw

**

LAS

Location

Loc Qty

Loc Code

GA

84

m129909

84

ST329

22

120560

9

m127363

13

MS21042L06

Purchased

No

110

Each

358.0000

7 14

DAS
06
3-89

MS21042L06

Nut

**

LAS

Location

Loc Qty

Loc Code

ST305

358

m127304

1

m129499

157

m130325

200

JAN 12 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Picklist Print

Wednesday, December 03, 2014 9:56:07 AM

Work Order ID: 126966

126966

Parent Item: D350-567-141

D350-567-141

Parent Item Name: Floor Window Close Out

Start Date: 12/15/14

Required Date: 12/19/14

Start Qty: 2.00

Required Qty: 2.00

MS21042L08

Purchased

No

110

Each

1,880.000

2

4

**

MS21042L08

Nut

LAS

Location

Loc Qty

Loc Code

ST304

1880

123900

1

125445

250

m127304

99

m127410

44

m128401

715

m128429

69

m129541

102

m130325

600

MS21042L3

Purchased

No

110

Each

1,208.000

5

10

**

MS21042L3

Nut

LAS

Location

Loc Qty

Loc Code

FP001

486

M130922

486

ST305

722

123900

20

M127410

11

M127831

41

M128401

34

M128754

16

M130799

600

JAN 12 2015

DAS

06

9-89

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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Wednesday, December 03, 2014 9:56:07 AM

Work Order ID: 126966

126966

Parent Item: D350-567-141

D350-567-141

Parent Item Name: Floor Window Close Out

Start Date: 12/15/14

Required Date: 12/19/14

Start Qty: 2.00

Required Qty: 2.00

MS21059L3 Purchased No 110 Each 257.0000 2 4 ****** DAS
86
9-89

MS21059L3

Nut Plate LAS

Location Loc Qty Loc Code

CA 9
M129682 9
ST303 248
M130823 248

MS35206-229 Purchased No 110 Each 2.0000

MS35206-229

Screw LAS
45
500

Location Loc Qty Loc Code

ST277 2
M129795 2

NAS1149F0332P Purchased No 110 Each 2,636.000

NAS1149F0332P

Washer LAS
45
500

Location Loc Qty Loc Code

ST260a 2000
m130325 2000
st268 636
122063 205
123900 10
125646 106
m127831 315

NAS1149FN616P Purchased No 110 Each 12.0000

NAS1149FN616P

WASHER LAS
45
500

Location Loc Qty Loc Code

st268 12
M127703 12

2 4 ******
7 14 ******
~~12723~~ 131078

12 24 ******
m131024 DAS
86
9-89
14 28 ******
131024 / JAN 12 2015 DAS
86
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Wednesday, December 03, 2014 9:56:07 AM

Work Order ID: 126966

126966

Parent Item: D350-567-141

D350-567-141

Parent Item Name: Floor Window Close Out

Start Date: 12/15/14

Required Date: 12/19/14

Start Qty: 2.00

Required Qty: 2.00

NAS1149FN816P

Purchased

No

110

Each

546.0000

2 4

NAS1149FN816P
WASHER

**

DAS
86
9-89

JAN 12 2015

DAS
46
0 00

Location

Loc Qty

Loc Code

st268

546

546

117316

4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
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Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-567 REV. E OR EARLIER
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-567 REV. 2 OR EARLIER
REF CANADIAN STC: SH92-18
FAA STC: SH989NE
FAA STC: SH990NE

1.0 Purpose

The purpose of this service instruction is to add the D350-567-141/-143/-145 Close-out Kits, which are intended for customers wishing to operate their aircraft with the interior floor window removed. The D350-567-141/-143/-145 Floor Window Close-out Kits provide a barrier around the interior and exterior vertical reference floor window to prevent objects from falling into the aircraft controls when the interior floor window is removed as shown in Figure 1. The -143 Kit is identical to the -141 Kit with the exception of the D4971-041 T/R Bellcrank Cover Assy which replaces the D4435-045 T/R Bellcrank Cover Assy on aircraft fitted with energy attenuating seats. The -145 Kit is similar to the -143 Kit but is only kit compatible with the AS350 B3e aircraft.

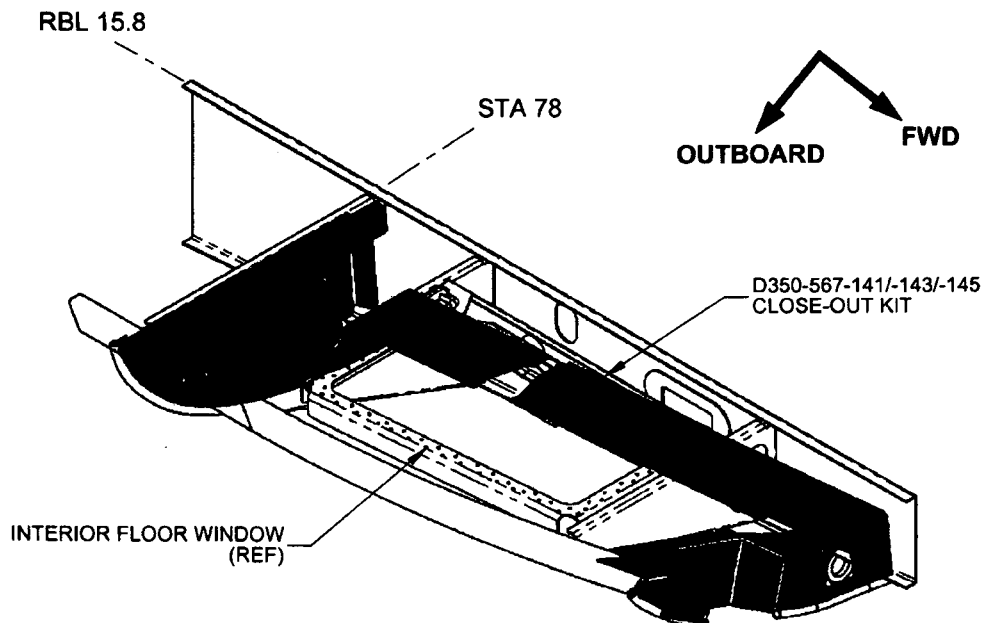


Figure 1. Floor Window Close-out Kit Installation

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED <i>[Signature]</i> BY: D. SHEPHERD (DE # 02)	
DATE:	14.03.20
CERT. NO.:	SH92-18
ISSUE NO.:	6

E	ADD -143/-145 KITS	RF	14.03.20
D	CLARIFY FIGURES 3-12	VS	13.09.11
C	CORRECT TYPO NAS1149FN816P WAS NAS1149FN882P	RF	12.03.13
B	MS35206-229 WAS AN525-632R6; NAS1149FN616P (Qty 14) WAS (Qty 9); MS21042L06 (Qty 7) WAS (Qty 9); ADD AN525-832R7, NAS1149FN882P & MS21042L08	RF	12.02.22
A	NEW ISSUE	RF	12.01.09
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	N/A	DSI 9590	SHEET 1 OF 19
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FLOOR WINDOW CLOSE-OUT KIT	NTS
DATE	14.03.20	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

2.0 Parts List

Qty -141	Qty -143	Qty -145	Part Number	Description
X			D350-567-141	FLOOR WINDOW CLOSE-OUT KIT (REGULAR SEATS)
	X		D350-567-143	FLOOR WINDOW CLOSE-OUT KIT (ENERGY ATTENUATING SEATS)
		X	D350-567-145	FLOOR WINDOW CLOSE-OUT KIT (AS 350 B3e)
1	1	1	D3802-1-024	SEAL (24")
1	1		D4434-041	FWD BRACKET ASSEMBLY
	1		D4434-047	COVER ASSEMBLY
1			D4435-045	T/R BELLCRANK COVER ASSEMBLY
2	2	2	D4435-9	BRACKET
1	1	1	D4436-041	AFT BRACKET ASSEMBLY
1	1	1	D4441-1-240	RUBBER SEAL (24")
		1	D4730-020-030	VELCRO STRIP
	1	1	D4971-041	T/R BELLCRANK COVER ASSEMBLY
		1	D5076-041	FWD BRACKET ASSEMBLY
7	5	5	AN3-3A	BOLT
2	2	2	AN525-10R6	SCREW
2	2	2	AN525-832R7	SCREW
		1	CB 200	3.5g ACRYLIC ADHESIVE
7	7	7	MS21042L06	NUT (OR MS21042-06)
2	2	2	MS21042L08	NUT (OR MS21042-08)
5	5	5	MS21042L3	NUT (OR MS21042-3)
2	2	2	MS21059L3	NUTPLATE
7	7	7	MS35206-229	SCREW
12	10	10	NAS1149F0332P	WASHER (AN960-10L)
14	14	14	NAS1149FN616P	WASHER (OR AN960-6L)
2	2	2	NAS1149FN816P	WASHER (OR AN960-8L)

E

3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141/-143/-145 Kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-567-141/-143/-145	3.9 lb	17.9 in	69.8 in-lb	65.5 in	255.5 in-lb
Floor Window Close-out Kit	1.77 kg	0.45 m	0.80 m-kG	1.66 m	2.94 m-kG

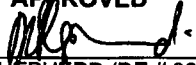
4.0 Installation Procedure

Notes:

- Figure 2 shows the general arrangement and installation of the D350-567-141/-143/-145 Close-out Kits. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
 - D350-567-115 - OK to remove D3295-041
 - D350-567-031 - OK to remove D3212-1
 - D350-567-011 - OK to remove D2214
 - D350-567-021 - OK to remove D2951
- It is acceptable to drill/trim the D350-567-141/-143/-145 Close-out Kits as required to improve fit.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

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BY: 
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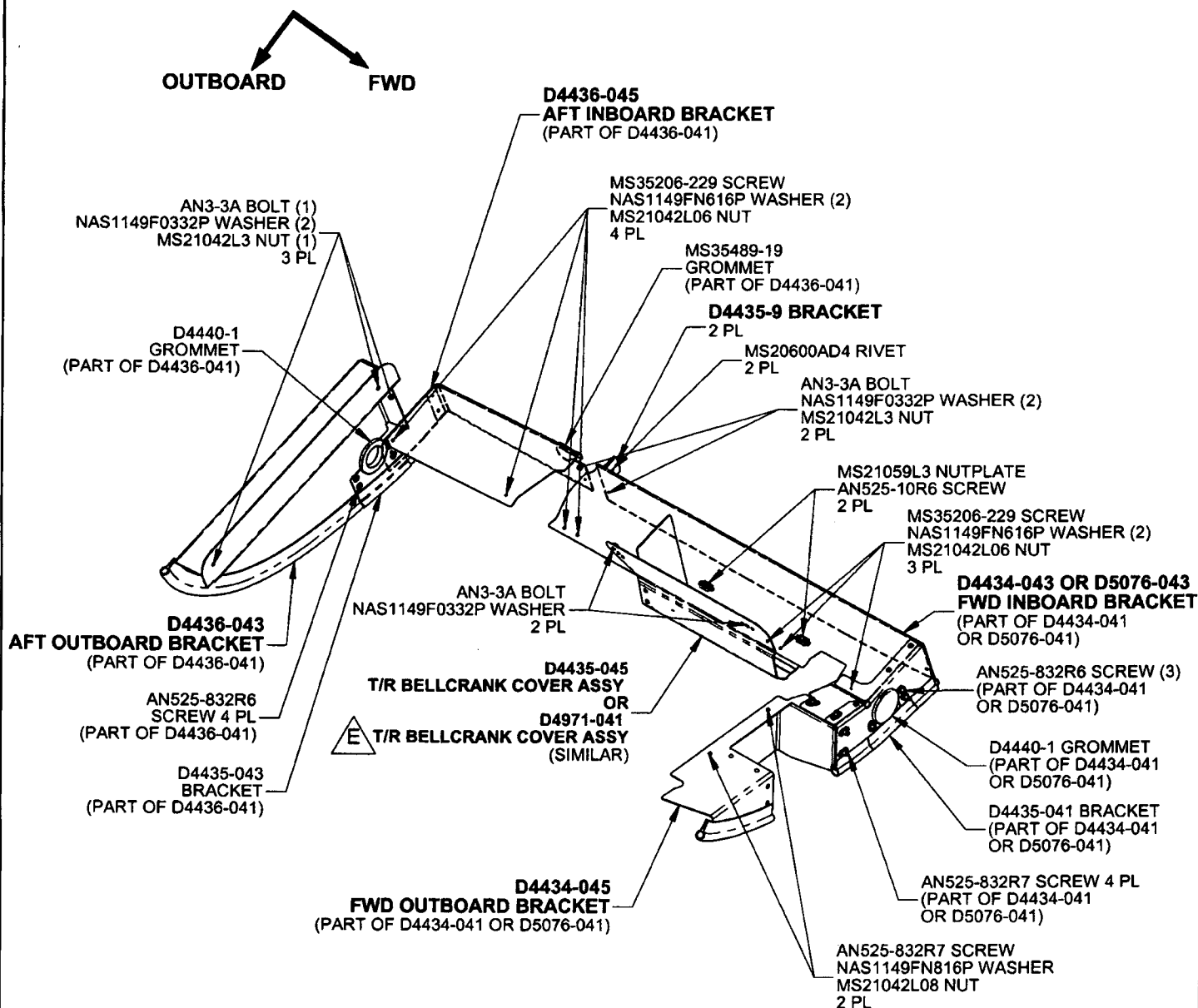


Figure 2. Floor Window Close-out Kit Installation

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4.1 Temporarily install D4436-043 Aft Outboard Bracket and D4436-045 Aft Inboard Bracket using clecos and/or cleco clamps. Before drilling holes:

- a) Position the D4436-043 Aft Outboard Bracket so the flange contacts the main beam as shown in Figure 3.
- b) Confirm that the D4436-043 Aft Outboard Bracket and beam angle are parallel as shown in Figure 4.

4.2 Temporarily install D4434-043/D5076-043 Fwd Inboard Bracket and D4434-045 Fwd Outboard Bracket using clecos and cleco clamps. Confirm there is no contact between D4436-045 Aft Inboard Bracket and D4434-043/D5076-043 Fwd Inboard Bracket and main beam gusset as shown in Figure 5.

4.3 For -143 installations, if aircraft is equipped with Collective Circuit Breaker Board box, trim D4434-043 Fwd Inboard Bracket as shown in Figure 14. Install D4971-041 T/R Bellcrank cover as shown in Figure 13b. Note: Confirm the D4434-047 Bracket fits over the Collective Circuit Breaker Board box. Adjust opening as required.

E 4.4 For -145 installations, if aircraft is equipped with Collective Circuit Breaker Board box, use D5076-043 Fwd Inboard Bracket as shown in Figure 13c. Install D4971-041 T/R Bellcrank cover as shown in Figure 13c. Note: Confirm the D5076-3 Cover fits over the Collective Circuit Breaker Board box. Adjust opening as required.

4.5 Drill out rivets holding plastic wire bundle stand offs. Transfer drill $\varnothing 0.144$ holes to D4436-045 Aft Inboard Bracket per Figure 6. Transfer drill 2 x $\varnothing 0.144$ holes to D4434-043/D5076-043 Fwd Inboard Bracket per Figure 7. Transfer drill 2 x $\varnothing 0.144$ holes for D4434-043/D5076-043 Fwd Inboard Bracket per Figure 8. Before drilling confirm the D4434-043/D5076-043 and D4436-045 brackets are flush with outboard edge of main beam flange. Assemble D4436-045 Aft Inboard Bracket and D4434-043/D5076-043 Fwd Inboard Bracket and wire bundle stand offs to main beam flange using MS35206-229 screw, NAS1149FN616P washer and MS21042L06 nut.

4.6 Install D4436-043 Aft Outboard Bracket using AN3-3A bolt and NAS1149F0332P washer and MS21042L3 nut per Figure 9.

4.7 Remove 2 rivets holding RH heating plastic stand off as shown in Figure 10. Position the D4435-9 Brackets on the in/outboard sides of the cross beam and transfer drill 2 x $\varnothing 0.129$ holes from crossbeam to both D4435-9 Brackets. Install D4435-9 Brackets and RH heating plastic stand off using MS20600AD4 rivets or equivalent.

4.8 Drill a pilot hole from D4435-9 Bracket to the D4434-043/D5076-043 Fwd Inboard Bracket and D4436-045 Aft Inboard Bracket and open to $\varnothing 0.191$. Install AN3-3A bolt, NAS1149F0332P washer and MS21042L3 nut as shown in Figure 10. Be sure to maintain edge distance.

4.9 Transfer drill 2 x $\varnothing 0.144$ holes from crossbeam to D4434-045 Fwd Outboard Bracket if holes exist in crossbeam. If holes do not exist, drill 2 x $\varnothing 0.144$ holes at either end of D4434-045 bracket as shown in Figure 11. Install AN525-832R7 screws, NAS1149FN816P washer and MS21042L08 nuts.

E 4.10 FOR D350-567-141 KIT

- a) Align D4435-045 T/R Bellcrank Cover Assy with existing holes in RH seat track lower frame and temporarily install using clecos and/or cleco clamps as shown in Figure 12a.
- b) Transfer drill 2 x $\varnothing 0.098$ holes from D4435-045 T/R Bellcrank Cover Assy to D4434-043 Fwd Inboard Bracket. Open holes to $\varnothing 0.191$ and install MS21059L3 nut plate into D4434-043 Fwd Inboard Bracket as shown in Figure 12a and Figure 13a. Install D4435-045 T/R Bellcrank Cover Assy using AN525-10R6 screw, AN3-3A bolt and NAS1149F0332P washer per Figure 12a and Figure 13a.

E 4.11 FOR D350-567-143/-145 KIT

- a) Remove the D4972-041 Side Plate Assy from the D4971-041 T/R Bellcrank Cover Assy and retain fasteners.
- b) Align D4971-1 T/R Bellcrank Cover with existing holes in RH seat track lower frame and temporarily install using clecos and/or cleco clamps as shown in Figure 12b.
- c) Bond D4730-020-030 Velcro to back of D4971-1 T/R Bellcrank Cover as shown in Figure 12b using CB 200 adhesive.

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MFG. APPR.	N/A	DSI 9590	SHEET 4 OF 19
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FLOOR WINDOW CLOSE-OUT KIT	NTS
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- d) Transfer drill 2 x $\varnothing 0.098$ holes from D4971-1 Cover Plate to D4434-043/D5076-043 Fwd Inboard Bracket. Open holes to $\varnothing 0.191$ and install MS21059L3 nut plate into D4434-043/D5076-043 Fwd Inboard Bracket as shown in Figure 13b/13c. Install D4971-1 Cover Plate using AN525-10R6 screws and D4730-020-030 Velcro per Figure 12b and Figure 13b/13c.
- e) Re-install the D4972-041 Side Plate Assy using the retained fasteners.
- 4.12 The D4440-1 grommets are provided to facilitate the routing of wiring harness thru the close-out kit as required. The wiring harness should be secure to the aircraft structure per AC 43.13.13-1B or AS350 Chapter 20.02.01.
- 4.13 Use the D3802-1-024 Seal to fill gaps between the brackets and the cowlings that are larger than 0.25 inch.
- 4.14 Perform travel/interference check of the flight controls to ensure there is no interference and all controls still have full travel.
- 4.15 Ensure there is a gap between the components of the D350-567-141/-143/-145 Close-out Kit and the aircraft structure so that the Close-out Kit does not chafe, interfere, or cause damage to the surrounding aircraft structure. In areas where the D350-567-141 /-143/-145 Close-out Kit may contact the aircraft structure, protect from abrasion using chafing tape or a layer Proseal 890 or MIL-S-8802 class B2 sealant or equivalent as required.

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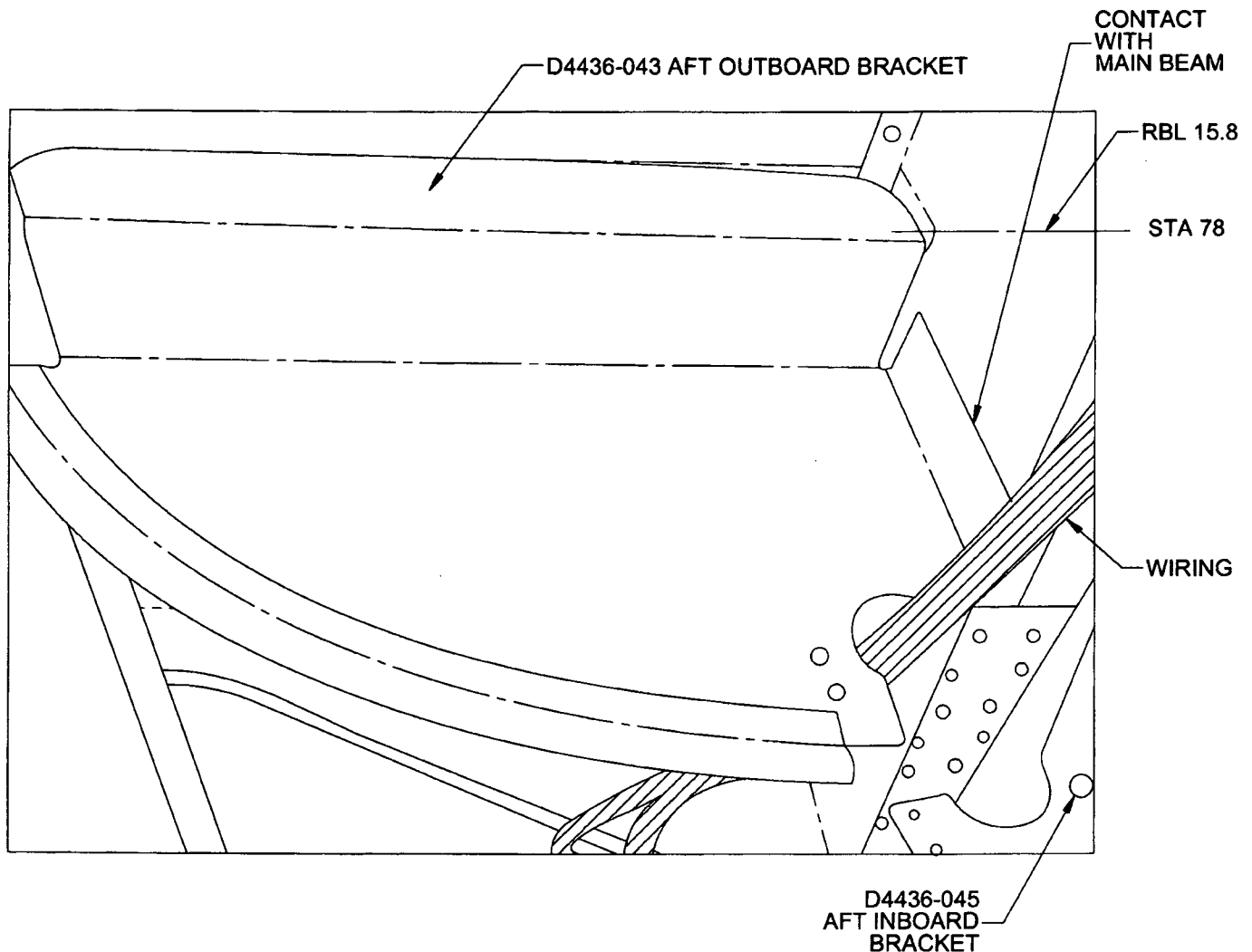


Figure 3. D4436-043 Aft Outboard Bracket Installation

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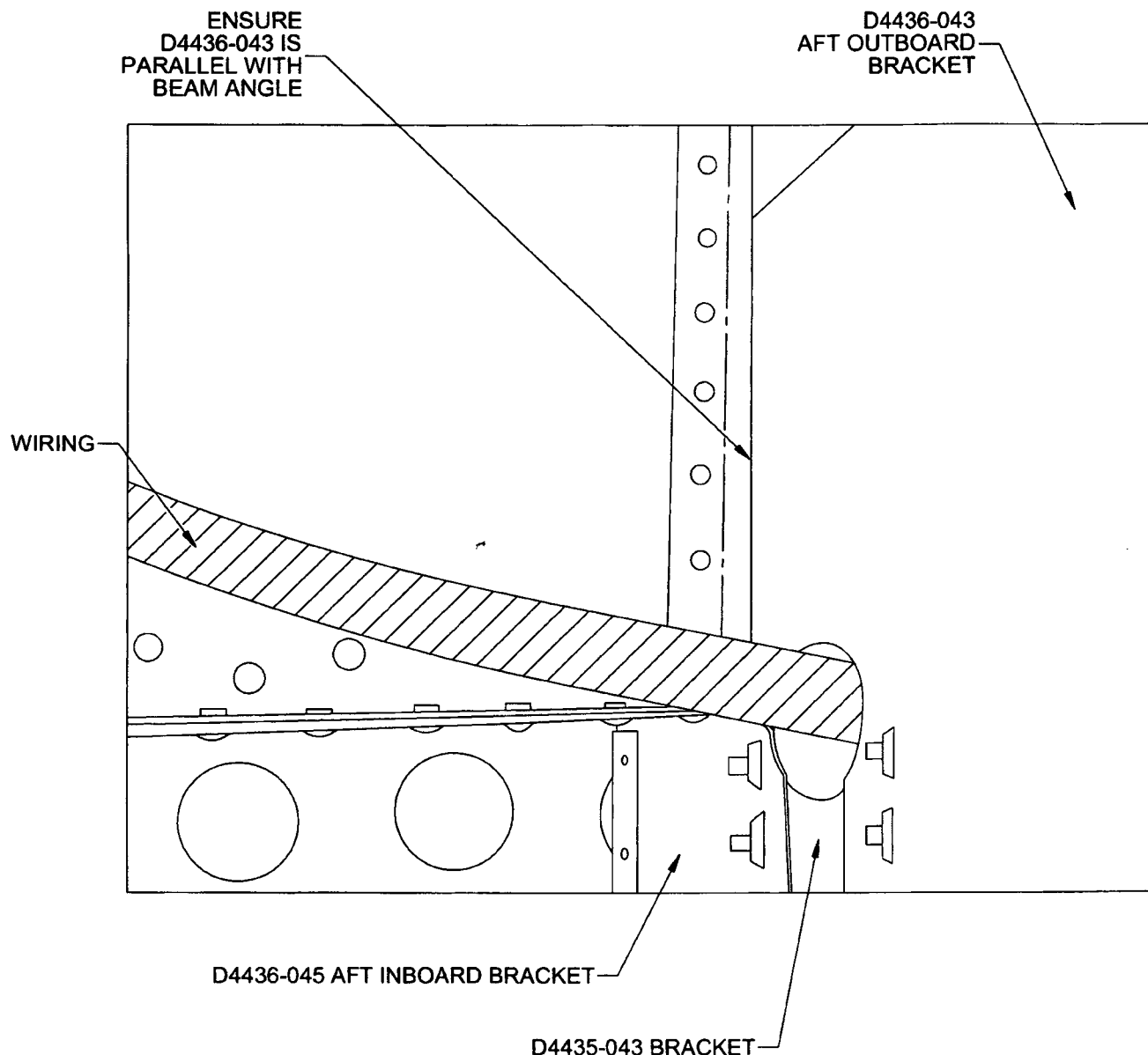


Figure 4. D4436-043 & D4435-043 Brackets Installation

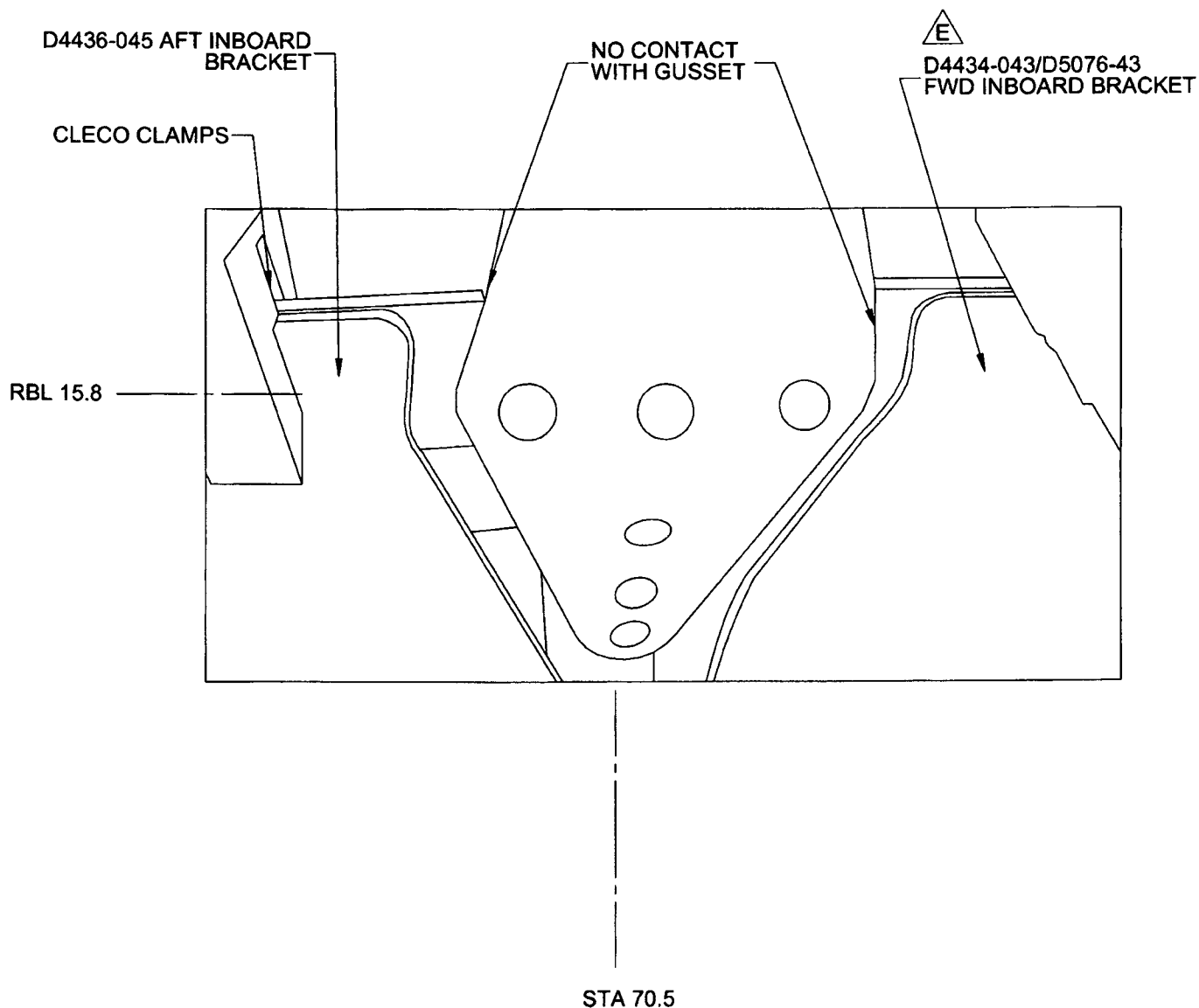
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△ E **Figure 5. D4436-045 & D4434-043/D5076-043 Brackets Installation**

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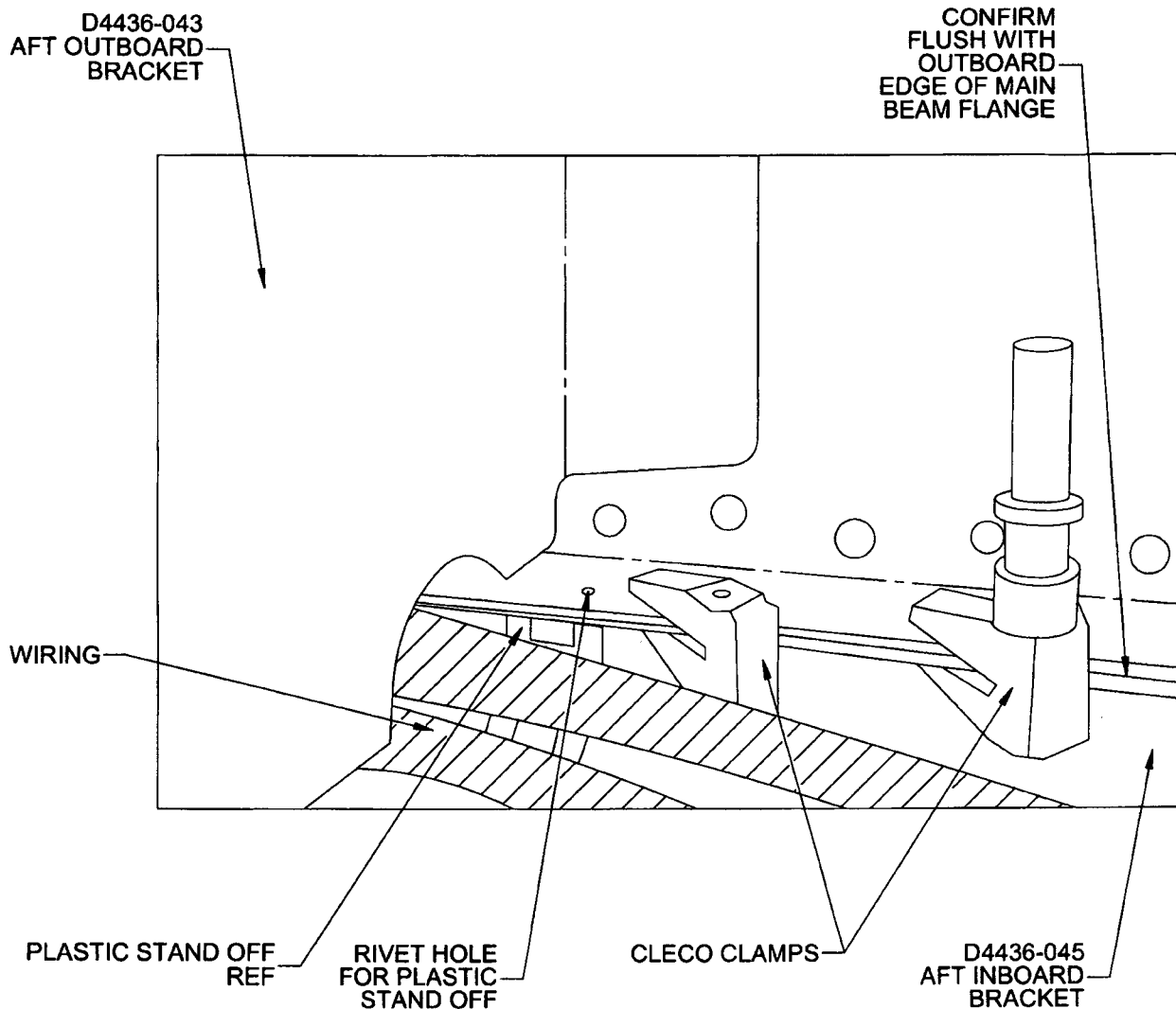


Figure 6. D4436-043 & D4436-045 Brackets Installation

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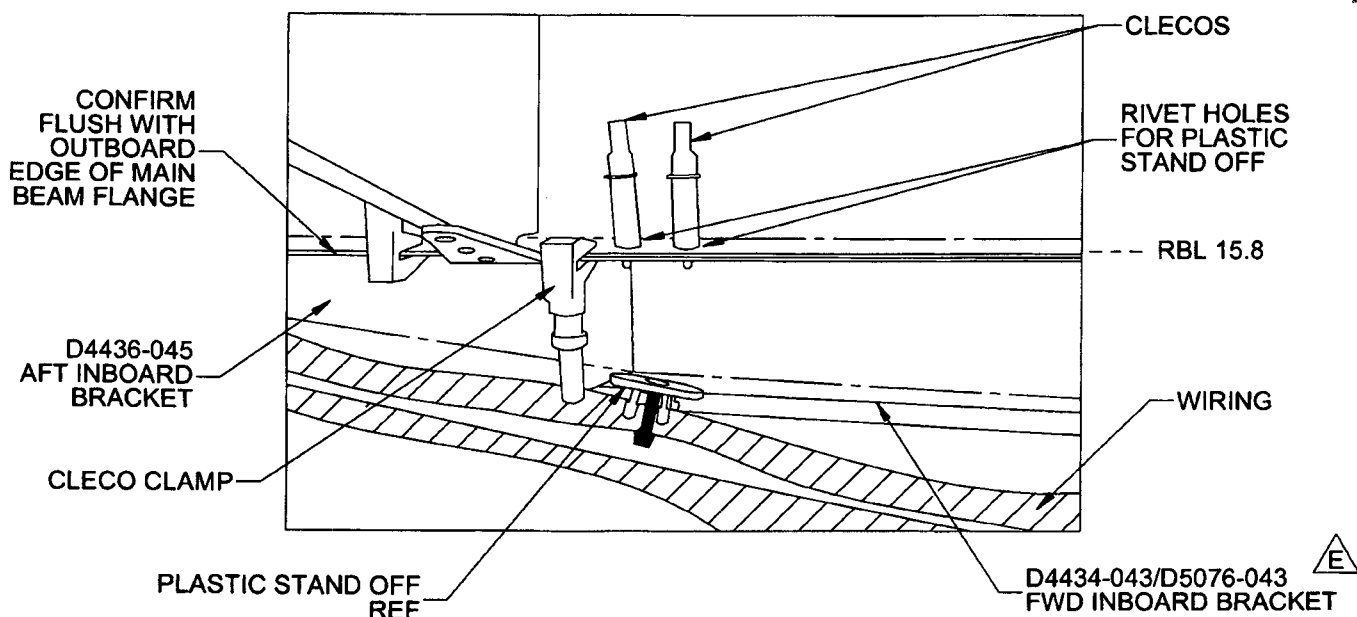


Figure 7. D4434-043/D5076-043 & D4436-045 Brackets Installation

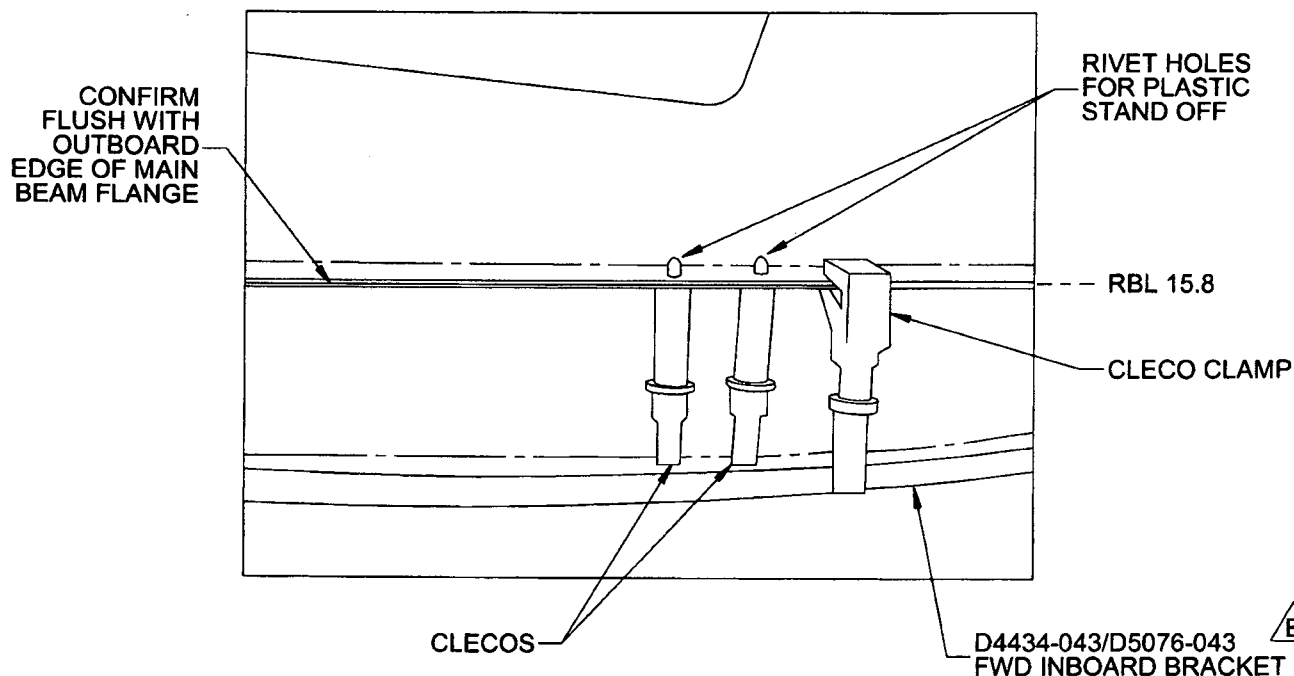


Figure 8. D4434-043/D5076-043 Fwd Inboard Bracket Installation E

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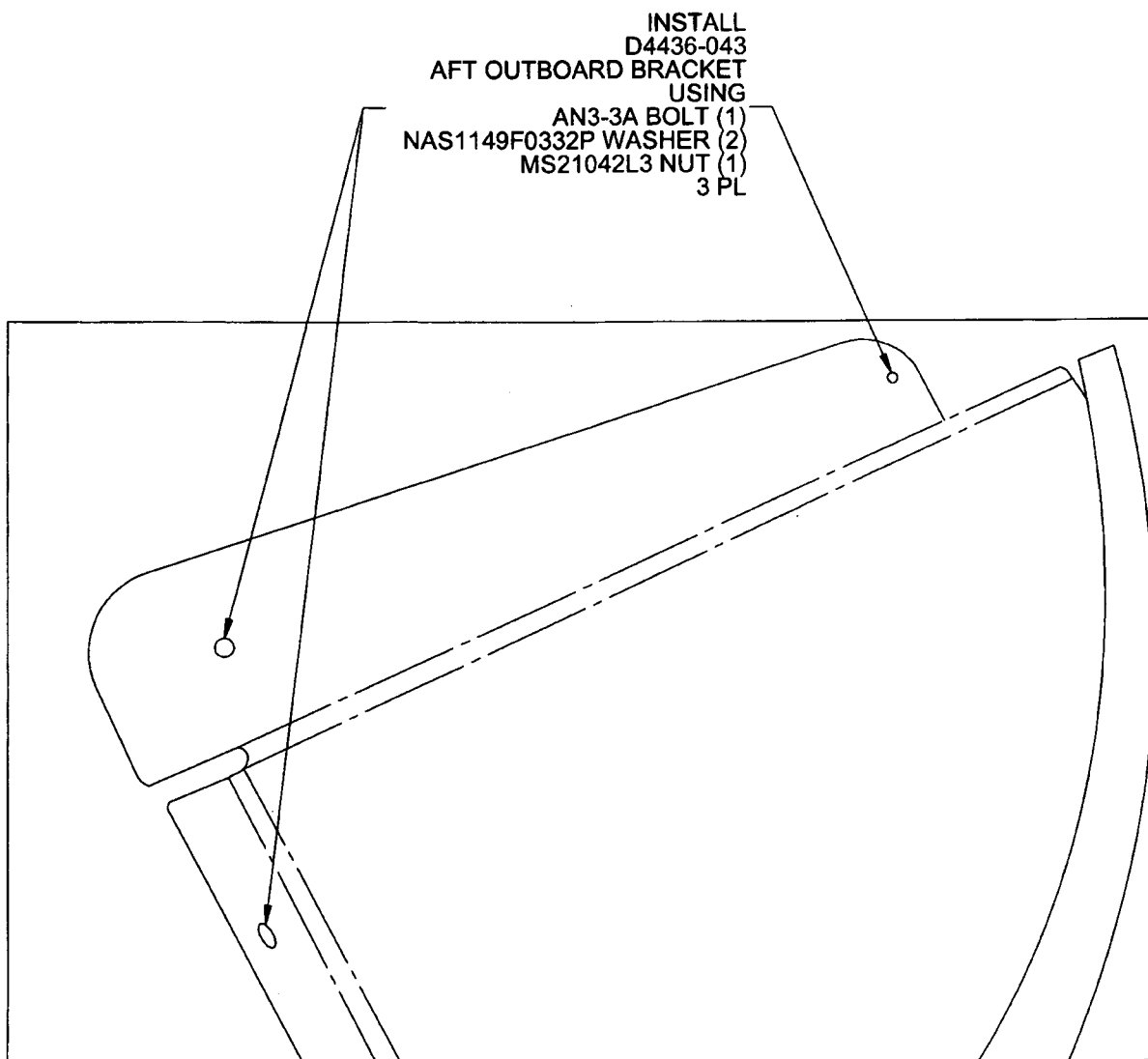


Figure 9. D4436-043 Aft Outboard Bracket Installation

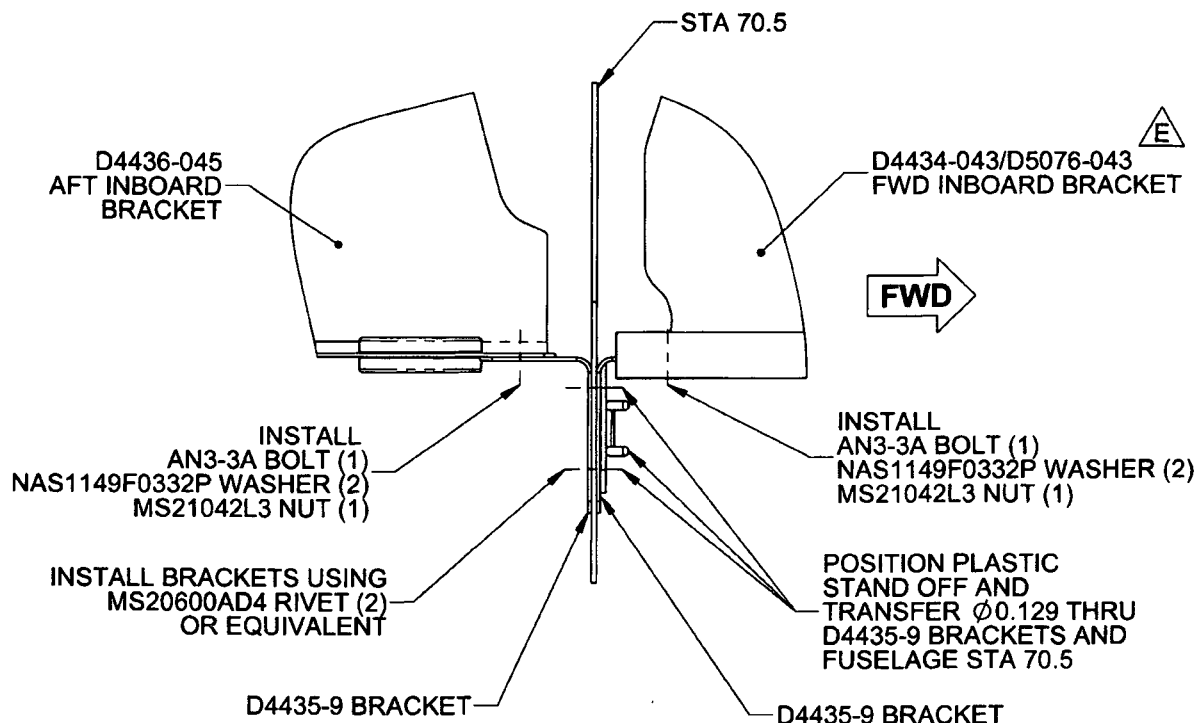
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LOOKING UP AT STA 70.5

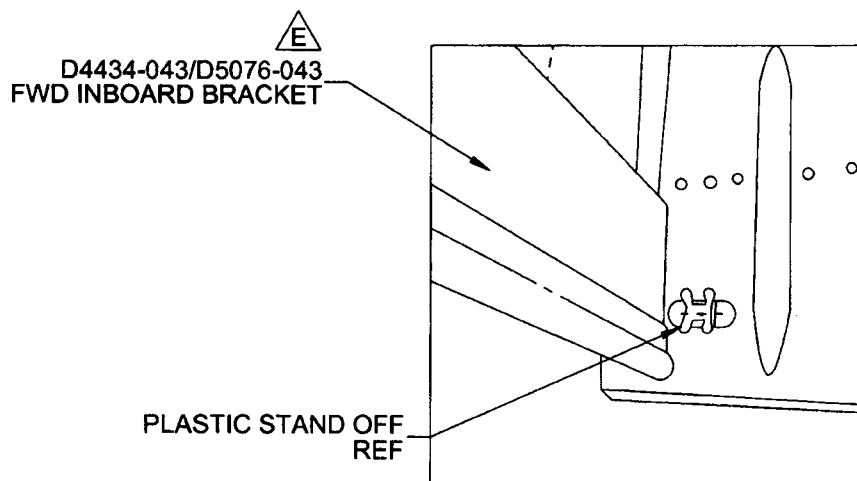


Figure 10. D4434-043/D5076-043 and D4435-9 Brackets Installation

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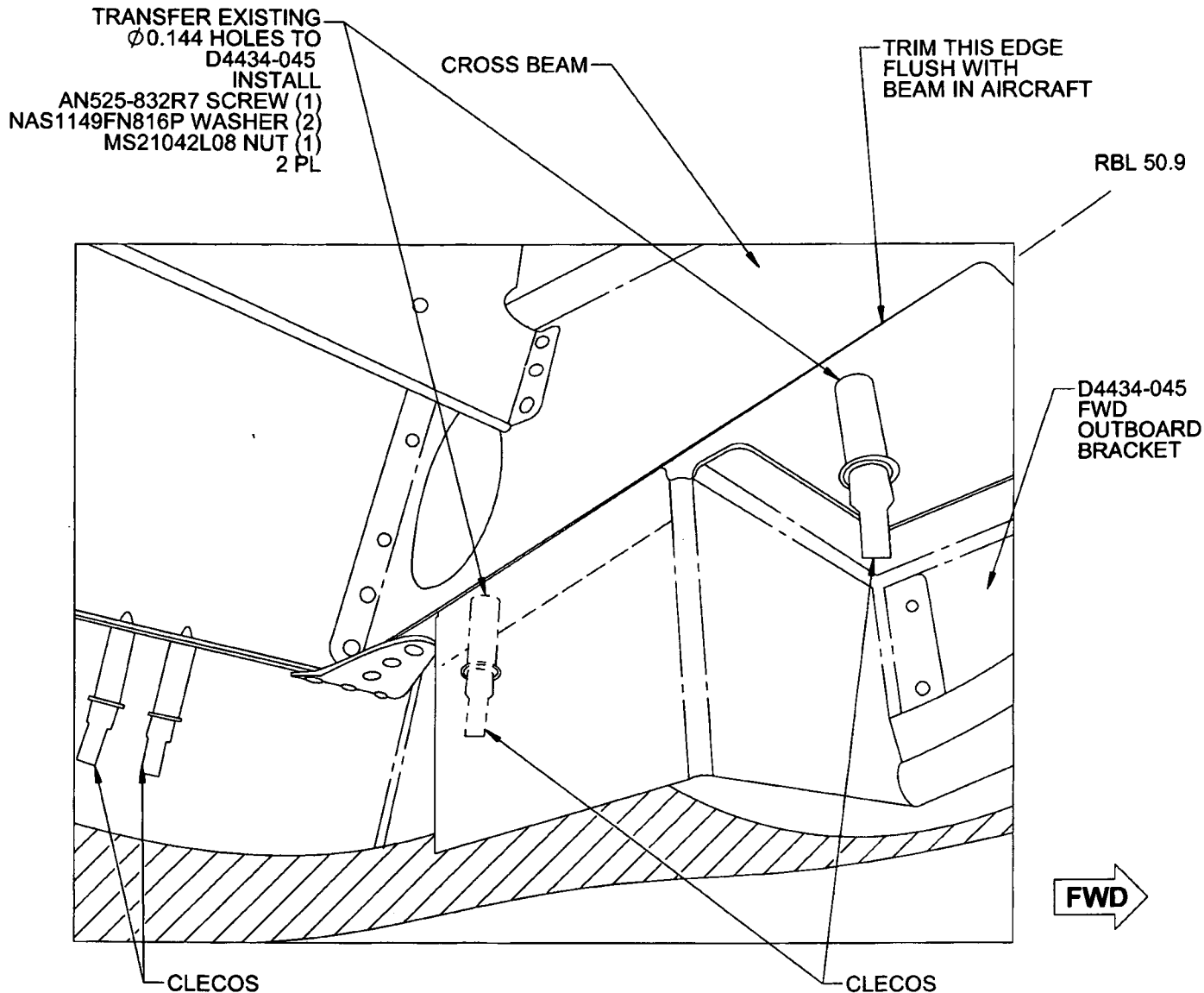


Figure 11. D4434-045 Bracket Installation

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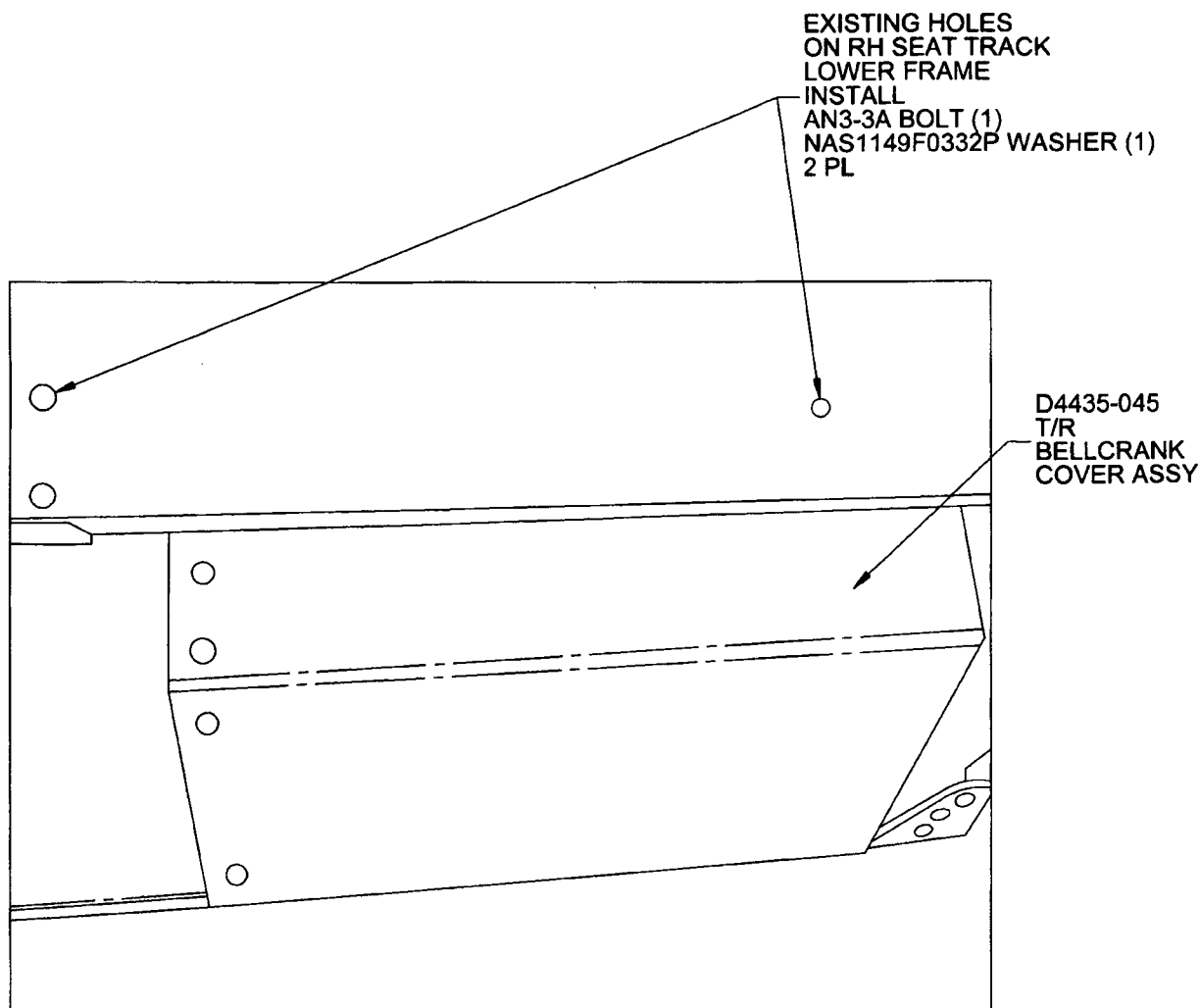


Figure 12a. D4435-045 T/R Bellcrank Cover Installation (-141)

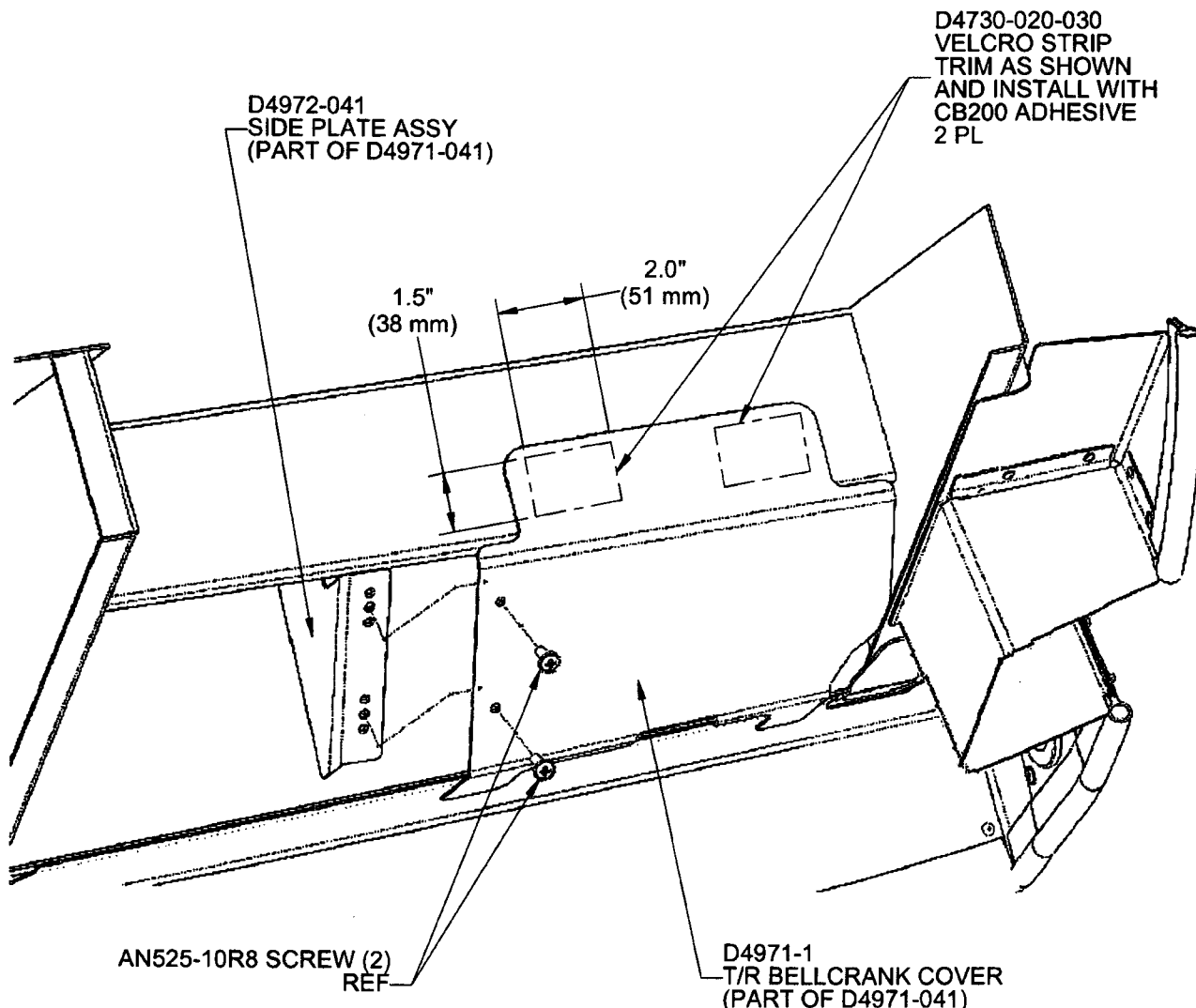
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E Figure 12b. D4971-041 T/R Bellcrank Cover Assy Installation (-143/-145)

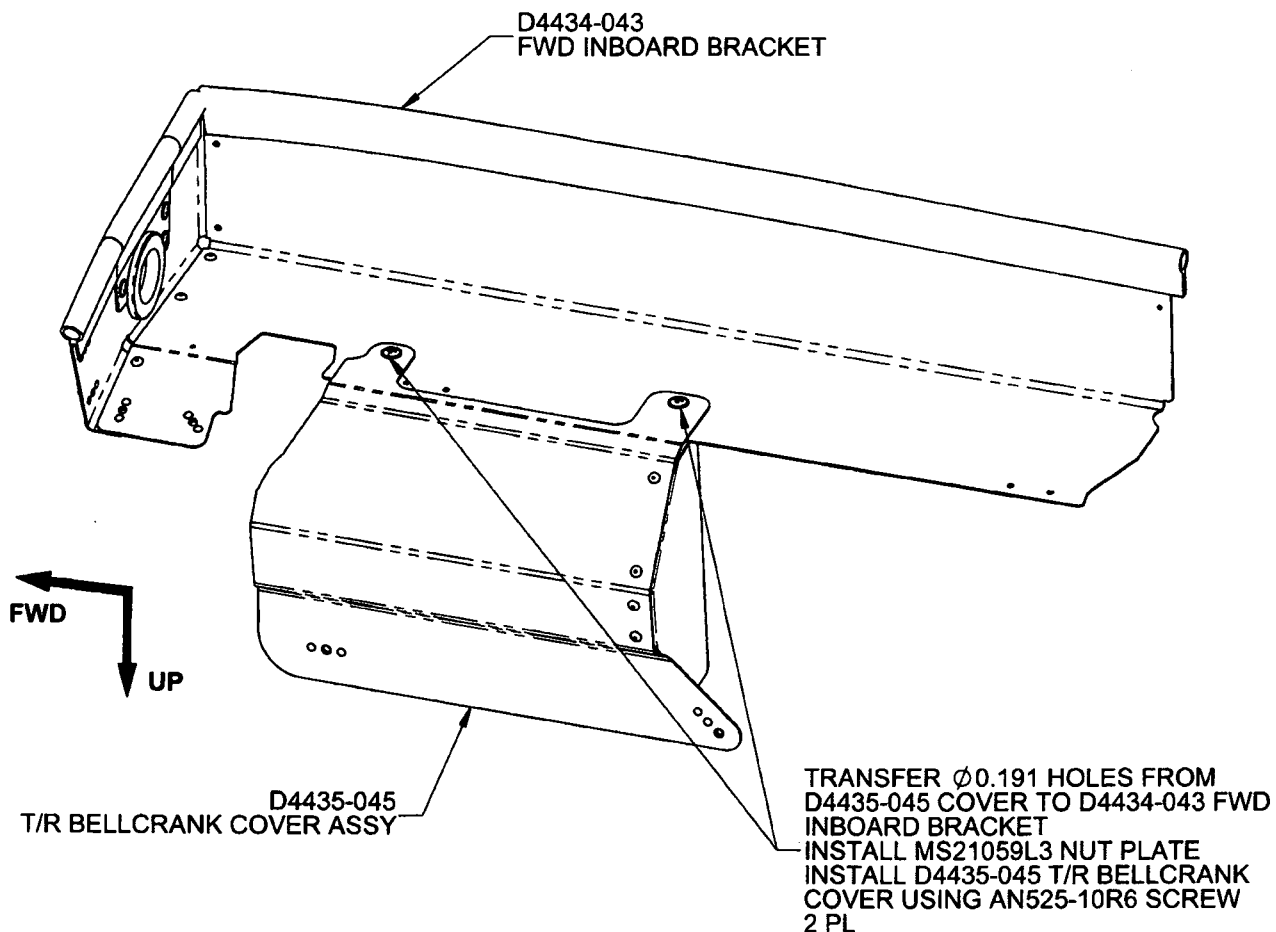
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E **Figure 13a. D4435-045 Cover Installation (-141 ONLY)**

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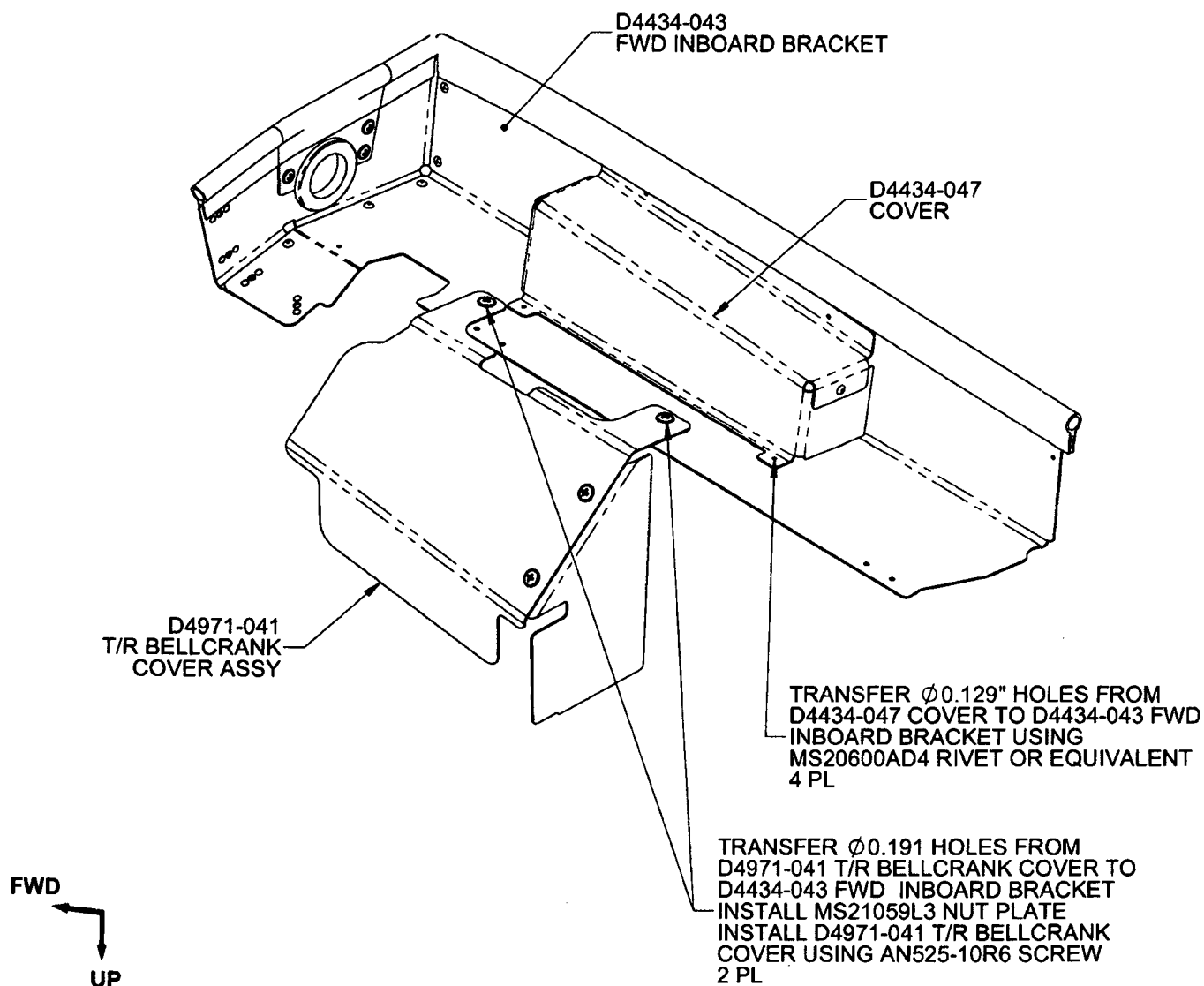


Figure 13b. D4971-041 & D4434-047 Cover Installation (-143 ONLY)

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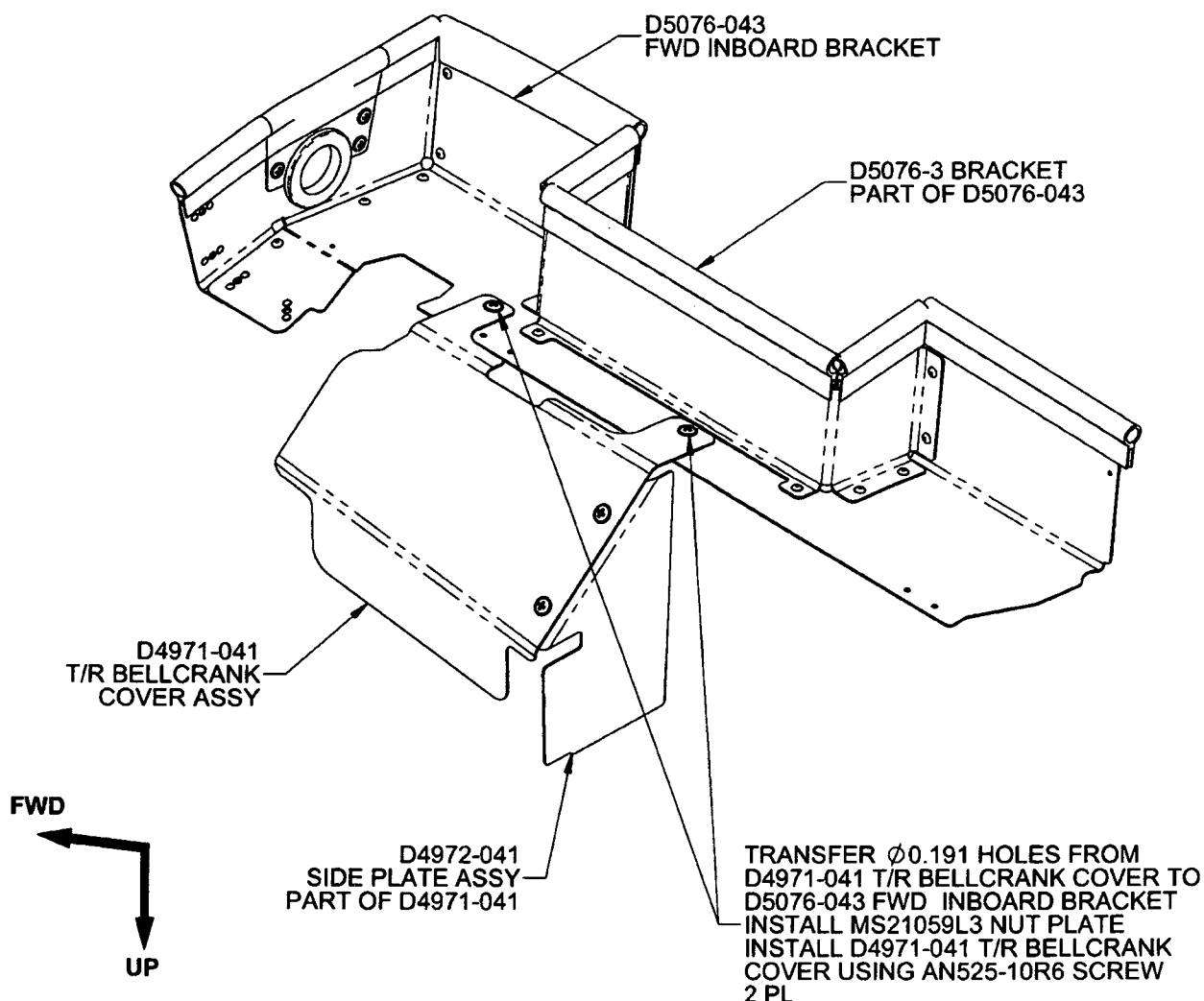


Figure 13c. D4971-041 INSTALLATION INTO D5076-043 (-145 ONLY)

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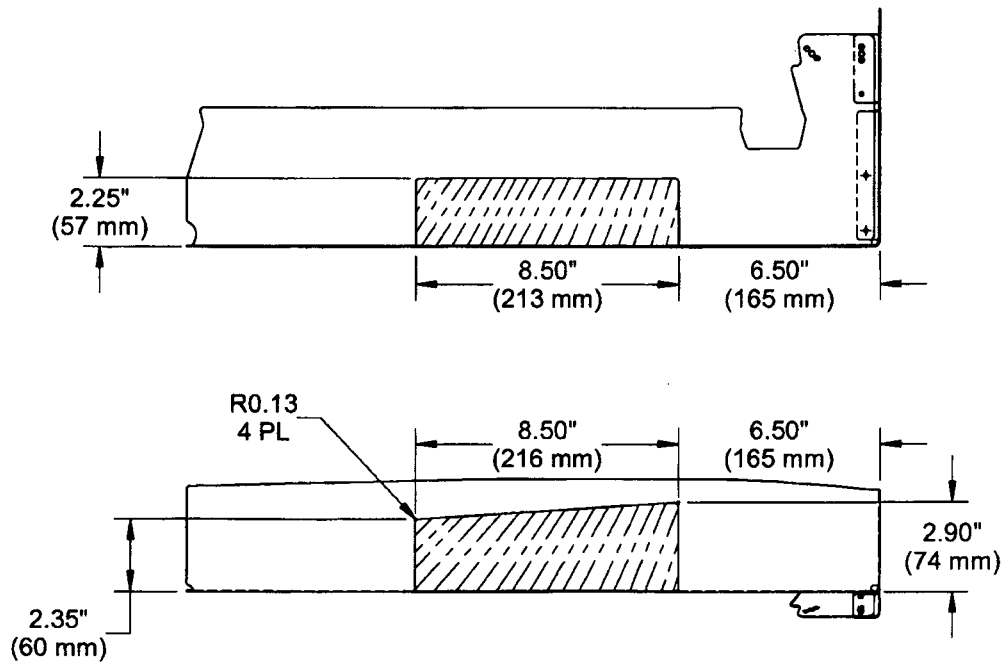
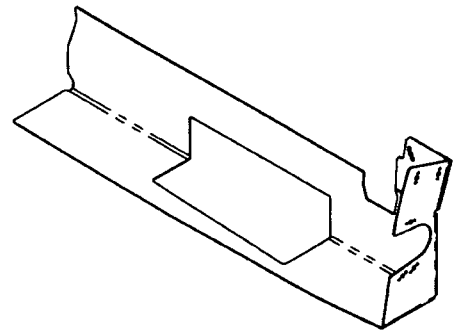
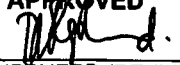


Figure 14. D4434-043 Fwd Inboard Bracket Cutout

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LAS
46

JAN 19 2015

2.0 Parts List

Qty -141	Qty -143	Qty -145	Part Number	Description
X			D350-567-141	FLOOR WINDOW CLOSE-OUT KIT (REGULAR SEATS)
	X		D350-567-143	FLOOR WINDOW CLOSE-OUT KIT (ENERGY ATTENUATING SEATS)
		X	D350-567-145	FLOOR WINDOW CLOSE-OUT KIT (AS 350 B3e)
1	1	1	D3802-1-024	SEAL (24")
1	1		D4434-041	*FWD BRACKET ASSEMBLY
	1		D4434-047	COVER ASSEMBLY
1			D4435-045	T/R BELLCRANK COVER ASSEMBLY
2	2	2	D4435-9	BRACKET
1	1	1	D4436-041	AFT BRACKET ASSEMBLY
1	1	1	D4441-1-240	*RUBBER SEAL (24")
		1	D4730-020-030	VELCRO STRIP
	1	1	D4971-041	T/R BELLCRANK COVER ASSEMBLY
		1	D5076-041	FWD BRACKET ASSEMBLY
7	5	5	AN3-3A	BOLT
2	2	2	AN525-10R6	SCREW
2	2	2	AN525-832R7	SCREW
		1	CB 200	3.5g ACRYLIC ADHESIVE
7	7	7	MS21042L06	NUT (OR MS21042-06)
2	2	2	MS21042L08	NUT (OR MS21042-08)
5	5	5	MS21042L3	NUT (OR MS21042-3)
2	2	2	MS21059L3	NUTPLATE
7	7	7	MS35206-229	SCREW
12	10	10	NAS1149F0332P	WASHER (AN960-10L)
14	14	14	NAS1149FN616P	WASHER (OR AN960-6L)
2	2	2	NAS1149FN816P	WASHER (OR AN960-8L)

3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141/-143/-145 Kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-567-141/-143/-145	3.9 lb	17.9 in	69.8 in-lb	65.5 in	255.5 in-lb
Floor Window Close-out Kit	1.77 kg	0.45 m	0.80 m-kG	1.66 m	2.94 m-kG

4.0 Installation Procedure

Notes:

- Figure 2 shows the general arrangement and installation of the D350-567-141/-143/-145 Close-out Kits. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
 - D350-567-115 - OK to remove D3295-041
 - D350-567-031 - OK to remove D3212-1
 - D350-567-011 - OK to remove D2214
 - D350-567-021 - OK to remove D2951
- It is acceptable to drill/trim the D350-567-141/-143/-145 Close-out Kits as required to improve fit.

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Work Order ID 126966

Wednesday, December 03, 2014 9:54:41 AM

126966

JAN 2015

Page 1

Item ID: D350-567-141

Revision ID:

Accept

N900040100

Setup Start *NS1*

Item Name: Floor Window Close Out

Stop *NS2*

Start Date: 12/15/14 Start Qty: 2.00

2

Required Date: 12/19/14 Req'd Qty: 2.00

2

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 14-12-03

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

DSI 9590

E

100

Document Control

0.00

100

DC

DOCUMENT CONTROL

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D350-567-141 CHG003

MLS 15-01-13

(2)

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

2

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control